

Date: Thursday, 4/12/2007 9:33:29 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET, GAS SPRING
Job Number	: 31782		
Estimate Number	: 10179		
P.O. Number	: <i>N/A</i>	Part Number	: D2144
This Issue	: 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2144 REV. D
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 28949	Material	: <i>N/A</i>
Written By	:	Due Date	: 5/10/2007 Qty: 20 Um: Each
Checked & Approved By	: <i>[Signature] 07.04.12</i>		
Comment	: Est: D 04.05.06 Reformat KJ/RF Est Rev:E Now on Waterjet 06-10-15 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0945 sf(s)/Unit Total : 1.8900 sf(s)

304/316 .063 Sheet 16GA

Batch: *M19052**SAD 07/05/08*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2144

Dwg Rev: *2*Prog Rev: *2*

2-Deburr if necessary

*SAD 07/05/08**20*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/05/08**20*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SG 07.05.08**20*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary

*ml 07/05/09**X 20*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 4/12/2007 9:33:29 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 31782

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144 Rev: D

SB 07/05/23 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/23 (20)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

1- Weld corner as per Dwg D2144 & QSI 004  
2- Grind flush

FC 07 05 28 (20)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/05/29 (20)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/29 (20)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103141

BR/M-L 07/05/29 (20)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/5/30 SB

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SB 210

6 7/5/30 SB (20)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/05/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 4/12/2007 9:33:29 AM  
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Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 31782

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

D07105/30

Job Completion



Le D07105/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

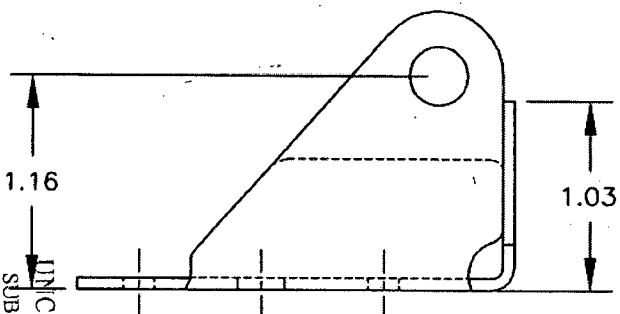
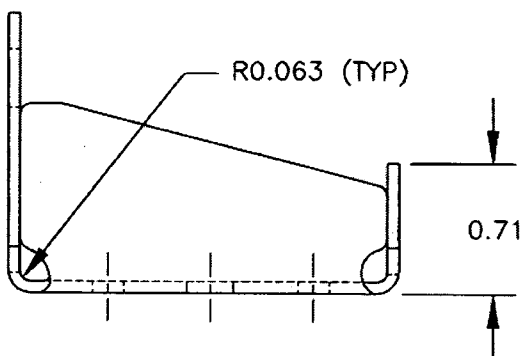
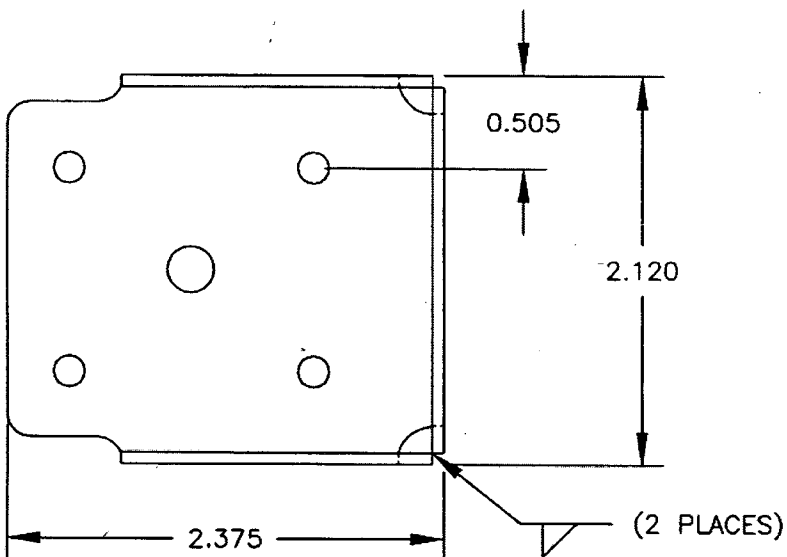
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED  
98.10.15 KE

DESIGN	bu	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
CHECKED	MA	APPROVED	KE	DRAWING NO. D2144	SHEET 1 OF 2
DATE	98.10.08	TITLE	HINGE BRACKET	SCALE	1:1
A	95.03.17	NEW ISSUE			
C	96.06.05	FLAT PATTERN LAYOUT ADDED			
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)			



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
WELD PER DART QSI 004

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

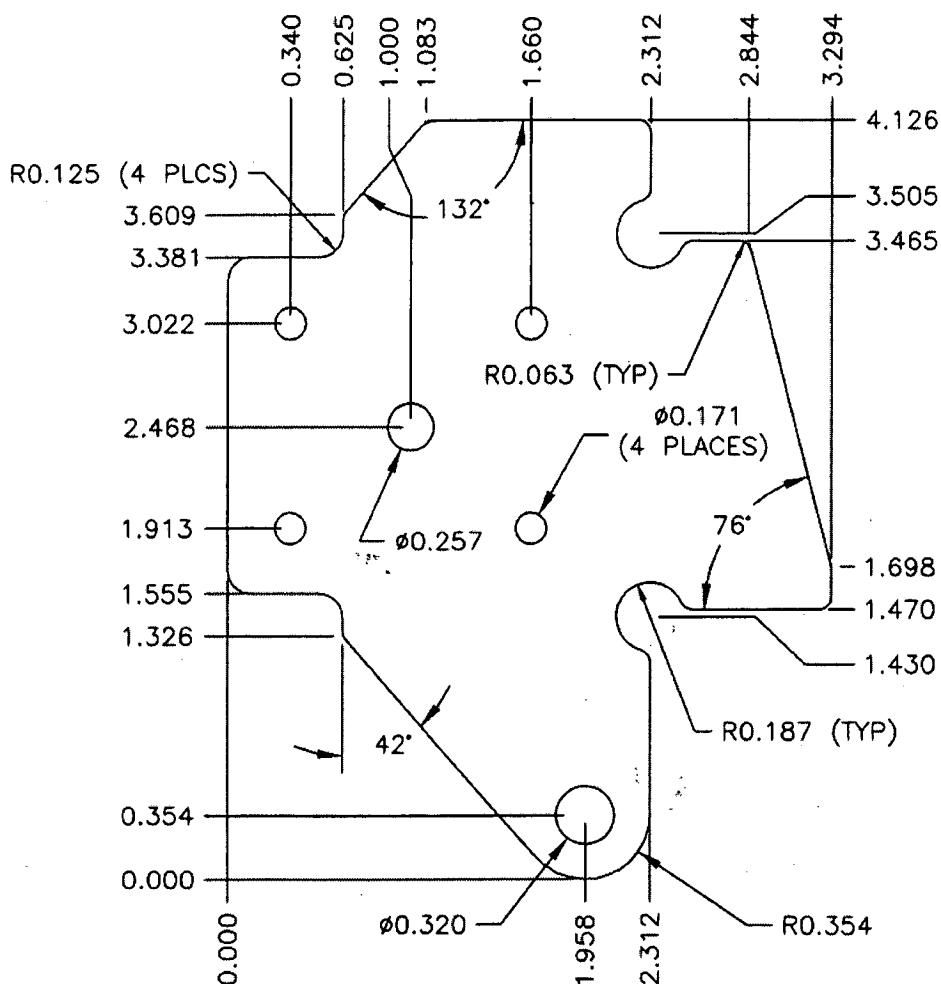
NO.

31782



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08		TITLE HINGE BRACKET	SCALE 1:1

RELEASED  
98-10-15 KE



SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 ORDER  
 NO. 31-782

MATERIAL: AISI 304/316-2B SS, 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE  
ALL DIMENSIONS ARE IN INCHES



DART AEROSPACE LTD		Work Order: 31782
Description: Hinge Bracket		Part Number: D2144
Inspection Dwg: D2144 Rev: 1		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.381	+/- 0.010	3.385	✓		height gauge	
B 3.022	+/- 0.010	3.016	✓		height gauge	
C 2.468	+/- 0.010	2.466	✓		height gauge	
D 1.913	+/- 0.010	1.910	✓		height gauge/vern	
E 1.555	+/- 0.010	1.550	✓		height gauge	
F 4.126	+/- 0.010	4.130	✓		Vern	
G 3.465	+/- 0.010	3.460	✓		height gauge	
H 0.340	+/- 0.010	0.346	✓		height gauge	
I 0.625	+/- 0.010	0.619	✓		height gauge	
J 1.000	+/- 0.010	0.997	✓		Vern	
K 1.083	+/- 0.010	1.082	✓		height gauge	
L 1.660	+/- 0.010	1.660	✓		Vern	
M 2.312	+/- 0.010	2.318	✓		height gauge	
N 2.844	+/- 0.010	2.850	✓		Vern	
O 3.294	+/- 0.010	3.298	✓		Vern	
P Ø 0.257	+0.006/-0.001	Ø 0.258	✓		Vern	
Q Ø 0.171	+0.003/-0.001	Ø 0.173	✓		Vern	
R Ø 0.320	+0.008/-0.001	Ø 0.320	✓		Vern	
S 0.354	+/- 0.010	0.351	✓		Vern	
T 0.063	+/- 0.010	0.059	✓		Vern	
U						
V						
W						
X						
Y						

Measured by: RAD	Audited by: BG	Prototype Approval:	N/A
Date: 07/05/08	Date: 07-05-08	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved